

Work Order ID 86855

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86855

Page 1

Item ID: D2274

Revision ID:

Item Name: Radius Block

Start Date: 7/06/12 Start Qty: 200.00

Required Date: 8/03/12 Req'd Qty: 200.00

Reference:

Accept

N900040100

Setup Start ***NS1***

Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2274	Rev F

100

0.00

100

SHEAR

Shear

Memo

0.00

Shear

blanks 9.00" long +/- 0.030" Note: 1 blank makes 9 pieces

110

0.00

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine as per folio D2274

120

0.00

120

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D2274 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Radius Block
 Start Date: 7/06/12 Start Qty: 200.00 ***200*** Cust Item ID:
 Required Date: 8/03/12 Req'd Qty: 200.00 ***200*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				417	1		
140 *140* Small Fab Small Fab	Small Fab Memo TumbleDeburr any rough edges after tumbling	0.00 0.00				417		7612731	
150 *150* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				417		7612731	

Dart Aerospace Ltd

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Item ID: D2274 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Radius Block
 Start Date: 7/06/12 Start Qty: 200.00 ***200*** Cust Item ID:
 Required Date: 8/03/12 Req'd Qty: 200.00 ***200*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: <u>ST008</u>	0.00							
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

4172 ϕ H wlos/31

200
4172 12/08/01 JB

12/8/11 JD

MLT 12/08/01

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Work Order ID: 86855

Parent Item: D2274

Parent Item Name: Radius Block

Start Date: 7/06/12

Required Date: 8/03/12

Start Qty: 200.00

Required Qty: 200.00

Comments: IPP H00.05.18Added inspection level 8EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6B00750X00.125		Purchased	No			100	f	114.5030	0.0916	19.28422			
6061-T6 Bar .750 x .125													

Location	Loc Qty	Loc Code
MAT001	111.168	
116406	2.75	
117653	8.418	
→ 122081	100	
MAT003	3.335	
120603	3.335	

20

and 12/07/26

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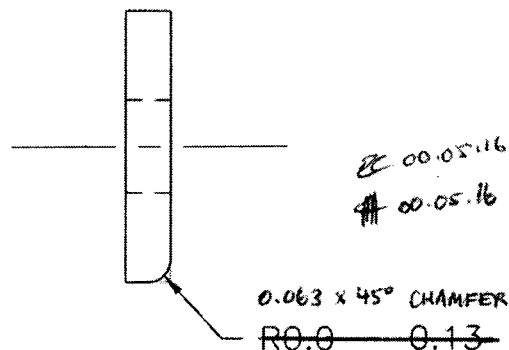
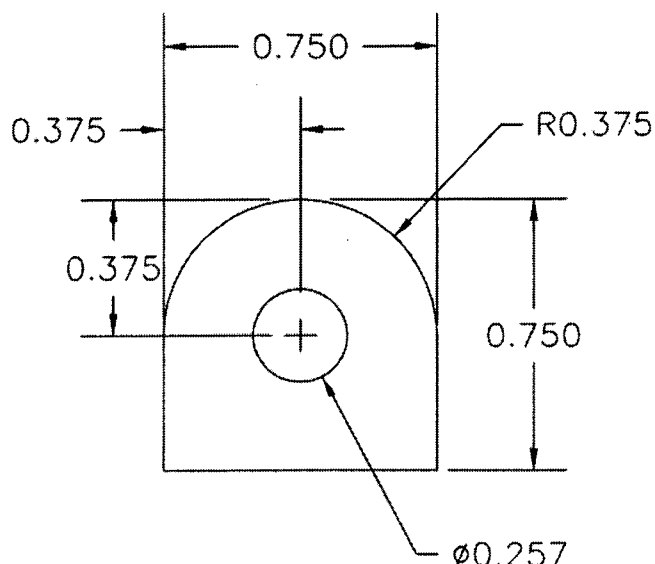
NOTE: Date & initial all entries



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2274	REV. F SHEET 1 OF 1
DATE 98.08.11		TITLE RADIUS BLOCK	SCALE 2:1
A	94.09.29	NEW ISSUE	
C	95.07.12	RADIUS ENDS	
D	97.03.24	ADD MATERIAL SPECIFICATION	
E	97.12.12	ADD FINISH & TOLERANCE QSI	
F	98.08.11	R0.0 - 0.13 WAS R0.063 - 0.125	

RELEASED
98/08/18 KE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 88855



MATERIAL: 5052-H34 (QQ-A-250/8) 0.125 THICK
OR 6061-T6 (QQ-A-250/11) 0.125 THICK
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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